

D206-628-021B2

BLUE

Dart Aerospace Ltd.

Date: Monday, 17/11/2008 10:39:30 AM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L /407 STEP ASSY, LH  
 Job Number : 43477A  
 Estimate Number : 11702  
 P.O. Number :  
 This Issue : 17/11/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D2724041  
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D2724 REV C  
 Previous Run : 40926A Drawing Revision : C  
 Material :  
 Written By : Due Date *SKIP* : 15/12/2008 Qty: 4 Um: Each  
 Checked & Approved By : *JUD 08.11.17*  
 Comment : Est Rev:E As Per Ecn 766 06-01-06 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion *B42155*

Check Material for any Dents or Defects

*SAD 08-11-17* (4)

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-1 using D2622 extrusion as per Dwg D2724

Deburr and bevel ends for welding

*SAP 08-11-17* (4)

3.0 D2734 Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

Qty Part Number Description Batch

2 D2734 End Cap *B39179* (8x)

*SP 08.11.18*

4.0 D34581 Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3458-1 Plate *B42635* (8x)

*SP 08.11.18*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 43477A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3458-3

Plate

B42636

SP 08.11.18

(8x)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig

DT (One End Only)

A/R AL ROD Batch:

M109213

M104855

SP 08.11.19

(4x)

Grind end cap welds flush

SAD 08-11-19 (9x)

7.0

QC9

VISUAL WELDING INSPECTION



SP 08-11-20



(4)

Comment: VISUAL WELDING INSPECTION

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/20 (4x)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. 08/11/22

(4x)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M 08 11 22



(4)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

SP 08.11.24

(4x)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 43477A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD Batch: 104855

SP 08.11.24 (4x)

Grind per dwg D2724

SAD 02-11-25 (4)

12.0

QC9

VISUAL WELDING INSPECTION



CP 08/11/25



Comment: VISUAL WELDING INSPECTION

BE 08-11-25 (4x)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/25 (4x)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

4x LH

Touch up Alodine

M-1

08/11/25

15.0

SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME -GREY

B 10992

-SPRAY PAINT DELFLEET BLUE

B 105918

-CLEAR DELFLEET

B 109816

ml

08 11 28 (4)

16.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

15.12.01 (4)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

M 109219

08-12-01

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION




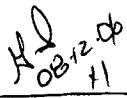



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/12/01 (4)

PH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2724-041 PAR #: N/A Fault Category: Prod/Finishing NCR: (Yes) No DQA: D Date: 08/12/09  
 Resolution: Rework Disposition: Rework QA: N/C Closed: D Date: 08/12/09

NCR: <u>43477A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/12/09	15.0	During main of boxes. employee caught the end of a step and caused it to fall to the floor. when it hit floor the paint chips		<ul style="list-style-type: none"> <li>- Apply touch up paint to <del>area</del> Paint chip per Q57005.</li> <li>- Apply touch up urethane to affected area.</li> <li>- Ensure no aluminum damage.</li> </ul>	 08-12-09 +1	 08/12/09		 08/12/09

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Job Number: 43477A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Rev F PPP 43477

08/12/05 xg

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/08 xg

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-12-08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

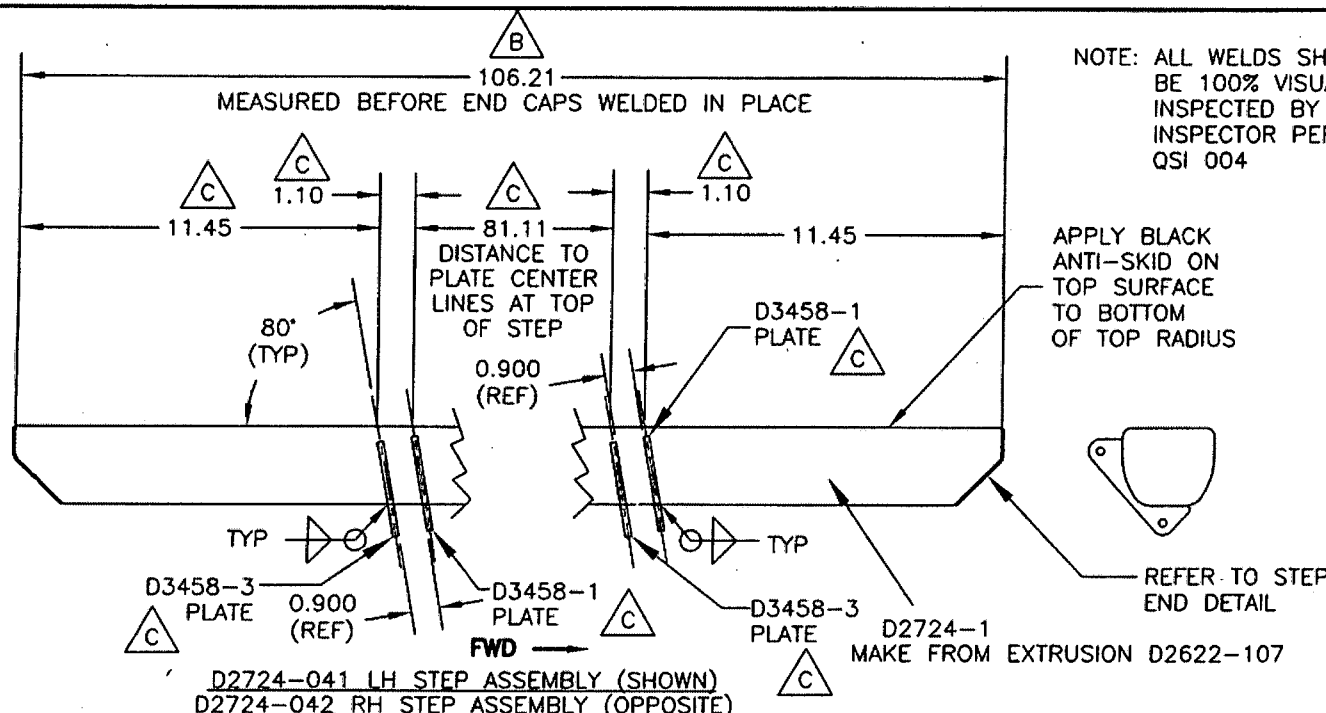
**NOTE:** Date & initial all entries



**DART**

RELEASED  
05.11.14

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004



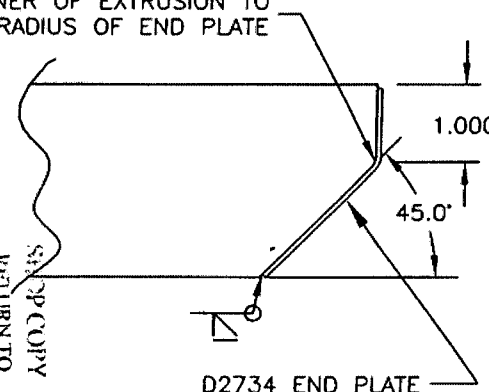
**D2721-041/-042 STEP ASSEMBLY PARTS LIST**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

**D2724-041/-042 STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 -  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE



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DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19	TITLE	D2724	DRAWING NO.
			206L/407 STEP ASSEMBLY	REV. C
				SHEET 1 OF 1
				SCALE
				NTS
				RE-DESIGN, ADD D3458-1/-3
				UPDATED WELD DETAIL REVISED TOLERANCES
				NEW ISSUE
				97.12.04
				98.10.19
				05.09.19